

Must ship/be assembled - Nov. 18

Work Order ID 126377

\*126377\*

Item ID: D3537-11 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Wearpad  
Start Date: 11/06/14 Start Qty: 4.00 \*4\* Cust Item ID:  
Required Date: 11/13/14 Req'd Qty: 4.00 \*4\* Customer:  
Reference:

Approvals: Process Plan: U Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	D								

100 0.00

\*100\*

FLOW WATER JET

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut D3537-3 as per Dwg D3537

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

110 0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC Memo 0.00

Quality Control

(4) 12/14/11/06

(4) 12/14/11/06

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Item ID: D3537-11 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
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Start Date: 11/06/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC8- Inspect parts - second check	0.00							DAS 3-38 9-89
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**\*120\***

QC

Memo

0.00

Quality Control

NOV 07 2014

130	Form as per dwg	0.00			DAS 30 9-89				
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**\*130\***

Brake NC

Memo

0.00

Brake NC

4

14/11/07

140	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
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**\*140\***

QC

Memo

0.00

Quality Control

4

NOV 07 2014

# Work Order ID 126377

**\*126377\***

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: <u>1130145</u> Large Fab	0.00				<u>4</u>			<u>14-11-10</u> <u>1182</u>
	Memo	0.00							
	A/R 2059B Hardcoat BATCH: <u>130145</u>								
160 <b>*160*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00				<u>4</u>		NOV 10 2014	DAS 24 9-89
	Memo	0.00							
170 <b>*170*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				<u>4</u>		NOV 10 2014	DAS 24 9-89
	Memo	0.00							

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

**Item Name:** Wearpad

Stop \*NS2\*

**Start Date:** 11/06/14      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 11/13/14      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:**                      **Date:**                      **Tooling:**                      **Date:**

**Stop** **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

**\*180\***

0.00

HandFinish

## Memo

## Hand Finishing

APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG  
AND QSI  
BATCH: 1302617

190

### QC3- Inspect Part Finish

0.00

**\*190\***

0.00

OC

## Memo

## Quality Control

DAS  
38  
9-89

NOV 17 2014

200

Identify as per dwg & Stock Location: E-2-66 0.00

0.00

**\*200\***

0.00

### Packaging

## Memo

## Packaging

**Work Order ID 126377****\*126377\***

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									

14/11/17  
②4-11-17

# Picklist Print

November-06-14 6:58:46 AM

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Work Order ID: 126377

**\*126377\***

Parent Item: D3537-11

**\*D3537-11\***

Parent Item Name: Wearpad

Start Date: 11/06/14

Required Date: 11/13/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.11.05 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

sf

473.5356

1

**\*M304S16GA\***

**\*\***

*De 14/11/06*

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

360.1356

M127821

71.317

M129449

192.8186

M130745

96

TPI

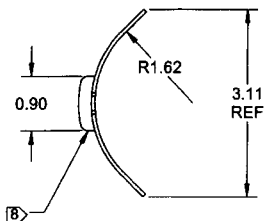
113.4

M129545

113.4

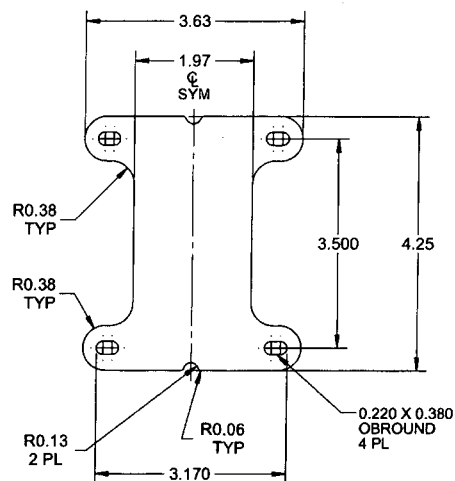
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\_\_\_\_\_  
*.6618*  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_





**D3537-1 WEARPAD**  
(MAKE FROM D3537-1F)

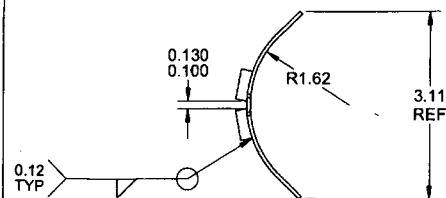
0.25  
TYP



**D3537-1F FLAT PATTERN**

**NOTES:**

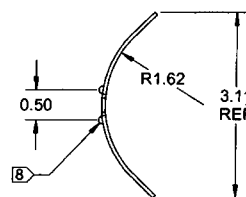
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-1" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.42 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



**D3537-5 WEARPAD**  
(MAKE FROM D3537-1F)

**NOTES:**

- 1-5) AS PER D3537-1
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-5" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.42 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



**D3537-9 WEARPAD**  
(MAKE FROM D3537-1F)

**NOTES:**

- 1-5) AS PER D3537-1
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-9" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.19 lbs
- 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
- 9) WELDING: PER QSI 004
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

**RELEASED**  
2014-11-05

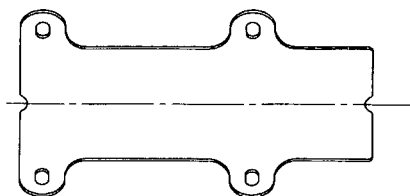
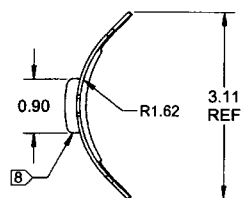
D	RE-FORMAT DRAWING, ADD -9/-11 WEARPADS	DB	14.10.16
C	WIDEN TAB TO 0.380, WELD PATTERN	CB	07.04.13
B	ADD AMS 5513 AND AMS 5524	CB	07.03.20
A	NEW ISSUE	CB	06.11.06
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. D
MFG. APPR.	DD	<b>D3537</b>	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	<b>WEARPAD</b>	NTS
DATE	14.10.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

APPROVED

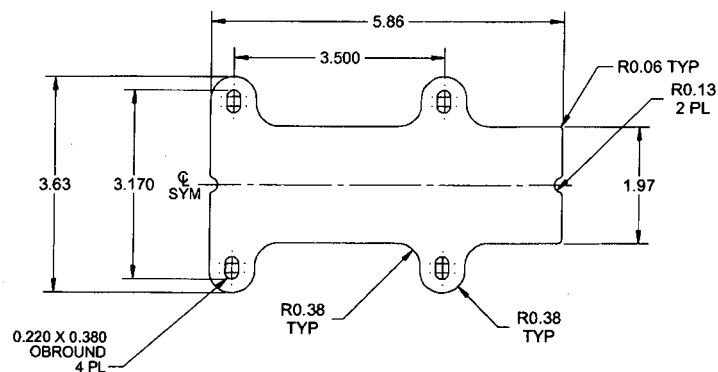
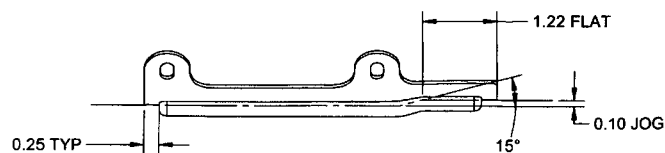
*WLO 126377*



8 7 6 5



**D3537-3 WEARPAD**  
(MAKE FROM D3537-3F)

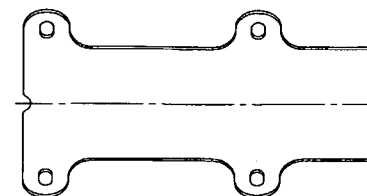
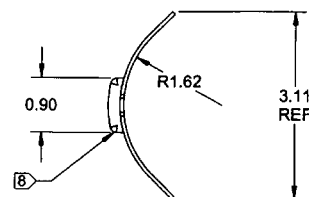


**D3537-3F FLAT PATTERN**

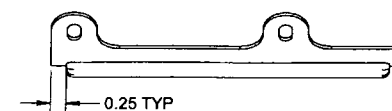
**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-3" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004

4 3 2 1

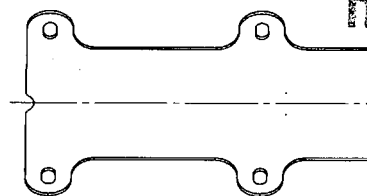
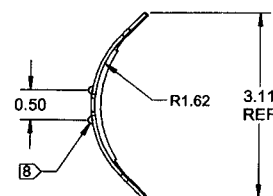


**D3537-7 WEARPAD**  
(MAKE FROM D3537-3F)



**NOTES:**

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-7" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



**D3537-11 WEARPAD**  
(MAKE FROM D3537-3F)

**NOTES:**

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-11" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.25 lbs
- 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
- 9) WELDING: PER QSI 004
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

APPROVED

DESIGN	DB	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. D
MFG. APPR.	DD	<b>D3537</b>	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	<b>WEARPAD</b>	NTS
DATE	14.10.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**RELEASED**  
2014-11-05